Work Order			*99855*								Page 1
Revision ID:	02369-3 Deck Plate Locator Bracke	ets 12.		Accept	*N900	1 040	110	N *	Setup Sta	1 /1	S1*
	/11/13 Start Qt	y: 4.90	*4* *4*		Cust Item Customer					' 'N	S2*
	Process Plan:MU					Date:			Run Star Sto	1/1	R1* R2*
Sequence ID/ Work Center ID	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	<u> </u>									
D2369	Rev A										
*100 *100* Waterjet FLOW CNC Waterjet		TER JET Memo G: Res A G: Res A		0.00				12	0		SM13-5-
*110 *110* QC Quality Control	,	t parts off machine F Memo	'AI/FAIB'	0.00				_12			<u>Jn13-5-</u>
120 *120* QC Quality Control		t parts - second check	k	0.00 R.S	7	·		12			

								DQA:	Date:	
NCR: Yes	/ No			WORK ORDER NON-	CONFOR	MANCE / UP		QA Closed:	Date:	
Work Order: Part No. NCR No.				DISPOSITION Rework Scrap Use-as-is Work Order Update	-i I:	Skid-tube Machining noforming Large Fab	AGAINST DE Crosstube Small Fab Finishing Composite	Pro	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	i	ction cription	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Dperator										

General **Landing Gear** Pressure/Forced Bend Grain Ovalized Bending Temperature/Cure BOM/Route Over/Under tolerance Centre Not Concentric to O/S Hardware Weld Part Incorrect Broken/Damaged Inspection Incomplete Cracks Wrong Stock Pulled Part Lost/Missing Instructions Incomplete/Unclear Crushed/Crimped. Burrs Part Moved Maintenance Cuffs Contamination Mislabeled Positioned Wrong Heat Treat Countersink Power Loss/Surge Other Misread Inspection Strip in Tube Cut Too Short Drill Holes Offset Ripples in Bend Out of Calibration Torque Waves in Extrusion Drawing Out of Sequence Finish Turning Sequence Folio Wave/Twist in Tube Outside Dimensions

FAULT CATEGORY

Setup
Other
Process
Supplier
Training
Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 2

April-12-13 8:28:03 AM Item ID: D2369-3 Accept *N900040100* Setup Start **Revision ID:** Item Name: Deck Plate Locator Brackets Start Date: 4/11/13 Start Qty: 4.00 Cust Item ID: Required Date: 4/11/13 Req'd Qty: 4.00 **Customer:** Reference: Run Process Plan: Date: Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID Description **Run Hours** Qty Code Qty Number Stamp 130 0.00 Small Fab *130* Small Fab Memo 0.00 Small Fab Deburr 140 QC5- Inspect part completeness to step on W/O 0.00 QC 0.00 Memo Quality Control 150 Identify as per dwg & Stock Location: *150* Packaging 0.00 Memo Packaging

											DQA:	Dat	e: _	
NCR: Y	es /	No				WORK ORDER NON-C	O	NFORM	ANCE / UPDAT				_	
·						P*					QA Closed:	Dat	e:	W 1280
Work Orde	ar:				:	DISPOSITION			,	AGAINST DEF	PARTMENT	PROCESS		
WOIK OIGE	=1. 					Rework	1		Skid-tube C	rosstube		Water Jet		Engineering
Part N	No.					Scrap			——	Small Fab	Pro	d. Eng. Coor.		Quality
						Use-as-is		Therm	noforming	Finishing	Rec/Stor	e/Packaging	╝	Other
NCR No.						Work Order Update]	I	Large Fab Co	omposite		Supplier		
Root					Descri	ption of work order update	1	nitial	Action		Sign &			
Cause		ate	Step	Qty	(or Non-conformance	Ch	ief Eng	Description	on	Date	Verification	1	QC Inspector
Doc/Data														
Equip/Tooling													-	
Operator														
Material							ŀ							
Setup													1	
Other														
Process										•				
Supplier														
Training										:			Ì	
Unapproved				<u> </u>			<u> </u>							
						F.	AUL	T CATE	GORY					
Landi	ng Gea	r			,——	General	_	7			1	r		
	Bei	nding				Bend		Grain			Ovalized	1		Pressure/Forced
	Cei	ntre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re	<u> </u>	Over/Under			Temperature/Cure
	Cra	icks				Broken/Damaged		4	on Incomplete		Part Incorre	1	\vdash	Weld
	Cru	ished/0	Crimped.			Burrs	_	4	ions Incomplete/Uncle	} -	Part Lost/M	issing		Wrong Stock Pulled
	Cu	ffs				Contamination		Mainte	nance		Part Moved			
	∐Не	at Trea	t			Countersink	L	Mislabe	led		Positioned V	· ·		•
	Ins	pectior	Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	Surge		Other
	Rip	ples in	Bend			Drill Holes		Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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April-12-13 8:28:03 AM

Quality Control

Item ID: D2369-3 Accept *N900040100* Setup Start Revision ID: Deck Plate Locator Brackets Item Name: Stop Start Date: 4/11/13 Start Qty: 4.00 Cust Item ID: Required Date: 4/11/13 Req'd Qty: 4.00 Customer: Reference: Run Process Plan: Date:_____ Approvals: Tooling: Date: Stop Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description **Run Hours** Qty Code Qty Number Stamp 160 QC21- Final Inspection - Work Order Release 0.00 MLJ 13-05-08 *160* QC 0.00 Memo

											DQA:	Date	2:	
NCR:	Yes	/ No				WORK ORDER NON-	O	VFORM	MANCE / UPDA			D - 1		
		·				T					QA Closed:	Date		
Mark Ord						DISPOSITION AGAINST DEPA						/PROCESS		
Work Orde	er. -	-			····	Rework		Skid-tube	Crosstube		Water Jet	Enginee	ering	
Part N	۷o.					Scrap	i	•	Machining	Small Fab	Pro	d. Eng. Coor.		ality
	•					Use-as-is	1	1	noforming	Finishing	Rec/Sto	re/Packaging		ther
NCR I	No.	·				Work Order Update]		Large Fab	Composite		Supplier	.]	
Root					Descri	ption of work order update		Initial	Actio	n	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descrip	tion	Date	Verification	QC In	spector
Doc/Data														
Equip/Tooling	Ш													
Operator	Ш													
Material	Ш						İ							-
Setup														
Other	\Box													
Process														
Supplier	Ш													
Training	Ш													
Unapproved			<u> </u>	<u> </u>				T CATE	CODY		<u> </u>		<u> </u>	
1 1		<u> </u>	<u> </u>			General	AUI	LT CATE	GURT					
Landi		Bending				Bend		Grain			Ovalized	Γ	Pressure/	Forced
<u> </u> 		Centre N	ot Conso	ntric to (\\ \-\	BOM/Route		Hardwa	ro	<u> </u>	Over/Under	tolerance	Temperat	
	-	Cracks	or concer	nuic to t),3	Broken/Damaged	-	4	on Incomplete	-	Part Incorre	<u></u>	Weld	ure, cure
	-	Cracks Crushed/	Crimpod		\vdash	Burrs	\vdash	- 4 '	ions Incomplete/Un	clear	Part Lost/M		→	ock Pulled
	-	Cuffs	стпрец.		-	Contamination	-	Mainte		-	Part Moved	_		
	-	Heat Trea	nt.		-	Countersink	\vdash	Mislabe		<u> </u>	Positioned \			
	\vdash	Inspectio		Tuhe	-	Cut Too Short	-	Misread		-	Power Loss,		Other	
	\vdash	Rinnles in		TUNE	\vdash	Drill Holes	\vdash	Offset		L	J. 2.1.5, 2555,	0-		

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

April-12-13 8:28:07 AM

Work Order ID: 99855

99855

Parent Item:

D2369-3

D2369-3

Parent Item Name: Deck Plate Locator Brackets

Start Date: 4/11/13

Required Date: 4/11/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev A

Removed from 9 Digit 05-12-05 JLM

IPP Rev:B

Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			110	sf	44.0000	1.354	5 .70 1053			
*M5052H3	32S 040	*							**	16-0		_	1m13-5-3

5052-H32 .040 Sheet

Location	Loc Qty	Loc Code	
MAT022	144.000045		
122406	15.000045	i	
124445	13		
124573	116		124573

Page 1

											DQA:	Date	:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	VFOR	MANCE / UPDA			_		
											QA Closed:	Date	•	
Work Orde	or.					DISPOSITION	DISPOSITION AGAINST DEPARTMENT/PROCESS							
WOIK OIG	٠,	-				Rework	1		Skid-tube	Crosstube		Water Jet	Engineering	
Part	No.								Small Fab		d. Eng. Coor.	Quality		
:	•					Use-as-is Thermoforming Finishing				Rec/Stor	e/Packaging	Other		
NCR No.						Work Order Update]		Large Fab C	Composite	Supplier			
Root					Descri	ption of work order update		nitial	Action)	Sign &		·	
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descript	ion	Date	Verification	QC inspector	
Doc/Data														
Equip/Tooling					i i									
Operator														
Material														
Setup	Ш							-						
Other														
Process					***	·	İ							
Supplier										•				
Training														
Unapproved				<u> </u>	<u> </u>									
							AUL	T CATE	GORY					
Landi		i				General		1			1	Г		
	_	Bending				Bend	<u> </u>	Grain			Ovalized	-	Pressure/Forced	
	\vdash	Centre No	ot Concer	ntric to	O/S	BOM/Route	_	Hardwa		ļ	Over/Under	⊢	Temperature/Cure	
		Cracks			<u> </u>	Broken/Damaged	<u> </u>	- 1 '	on Incomplete		Part Incorre	· -	Weld	
	-	Crushed/	Crimped.		·	Burrs	\vdash	-1	ions Incomplete/Unc	lear	Part Lost/M	issing	Wrong Stock Pulled	
		Cuffs			<u> </u>	Contamination	-	Mainte		<u> </u>	Part Moved	• •		
	\vdash	Heat Trea			-	Countersink	\vdash	Mislabe		ļ	Positioned V			
	-	Inspectio		Tube	<u> </u>	Cut Too Short	<u></u>	Misread	d		Power Loss/	Surge	Other	
		Ripples in	n Bend			Drill Holes	1	Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	99855
Description: Deck Plate Locator Bracket	Part Number:	D2369-3
Inspection Dwg: D2369 Rev: A		Page 1 of 1

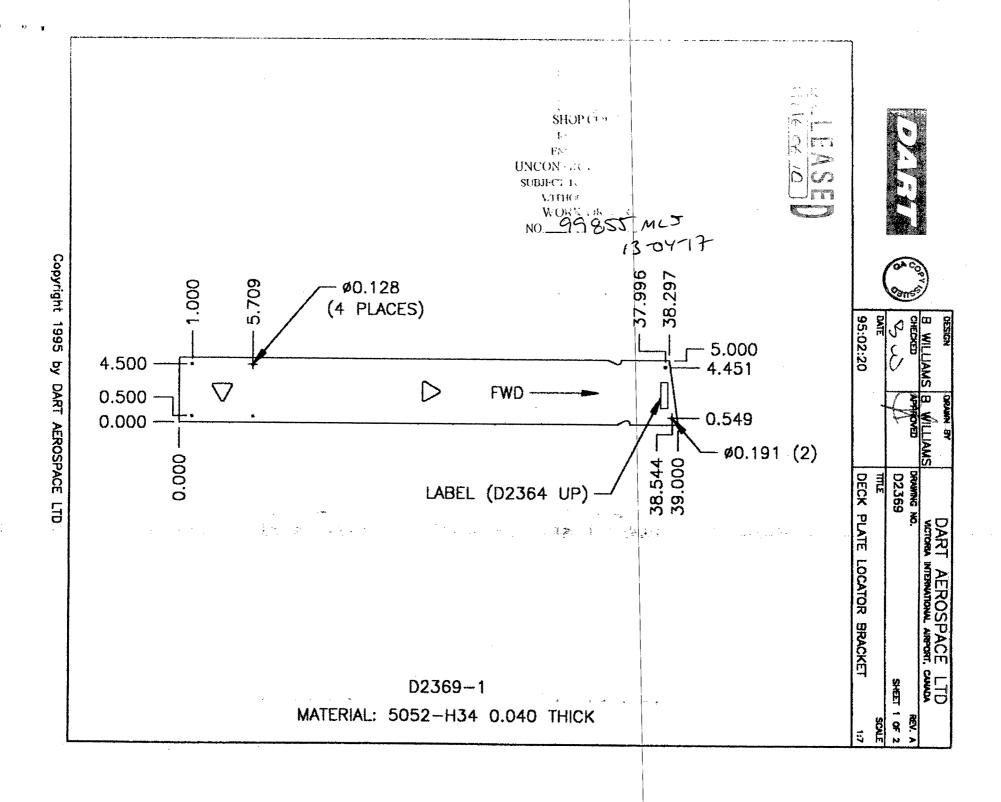
FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	0,501,	_			
4.500	+/-0.010	4.502"	-			
5.709	+/-0.010	5.709"	-			
Ø0.128	+0.005/-0.000	0.128	_			
37.990	+/-0.010	37.990	-			
38.297	+/-0.010	38.297	J			
5.000	+/-0.010	5.007	·-		. 7	
4.490	+/-0.010	4.495	-		·	
0.664	+/-0.010	0,664	-			
39.000	+/-0.010	39.000"	_		7.	
38.528	+/-0.010	38-528	- 1		l.	
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Measured by: Jm	Audited by:	27	Prototype Approval:	N/A
Date: 13-5-	Tage Date:	13.57	Date:	N/A

	Rev	Date	Change		Revised by	Approvéd
I L	Α	04.06.25	New Issue	P/O D350-616-015	KJ/JLM	
				***	· · · · · · · · · · · · · · · · · · ·	



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